Work Orde	er ID 96833 8:24:24 AM		*968	333*	5	nif	Ma	arch	<i>)</i>	Page I
Item ID: Revision ID:	D3935-2 Pylon Protector		Accept	*N900	<u>040</u>	100)* ፡	Setup Star Stop	ΙŅ	S1*
Start Date: 2. Required Date: 2. Reference:	2/07/13 Start Qty: 2 3/22/13 Req'd Qty: 2			Cust Item I Customer:	D:			·	, IVI	5)"
Approvals:	Process Plan: ML5 QC:	Date: <u>1</u> 3-02-0	_		ate:		1	Run Star Stop	1/7	R1* R2*
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3935	В	 	0.00		· · - · · - ·					
100 Waterjet FLOW CNC Waterjet	Dwg Prog	o t as per Dwg D3935 Rev:	0.00				_a_	<u> </u>	<i>J</i> ,	m13-2-21
110 * 11 0*		s off machine FAI/FAIB	0.00							

0.00

Memo

Quality Control

DQA:_____

Date:

NCR: Y	es / No				WORK ORDER NON-C	JON	iFUKI	VIANCE / UP	DATE	QA Closed:	Date	:
Work Orde	···				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root		[Descri	ption of work order update		nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	-											
Material												
Setup [
Other												
Process												
Supplier												
Training												
Unapproved		<u> </u>						<u>L</u>				<u> </u>
	·					AUL	T CATE	GCIRY				
Landir	ng Gear			_	General	_	l			1	г	٦
,	Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized	-	Pressure/Forced
ļ	Centre N	ot Conce	ntric to C	^{)/s} -	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure Weld
	Cracks			 	Broken/Damaged	-	1	ion Incomplete	// to along	Part Incorre	 	Wrong Stock Pulled
İ	Crushed/	'Crimped		-	Burrs	-	Mainte	tions Incomplete/	Unclear	Part Lost/M Part Moved	rssing [
	Cuffs			-	Contamination Countersink	\vdash	Mislabe			Positioned V	Mrong	
	Heat Tre		Tulaa	<u> </u>	Cut Too Short	-	Misrea		 	Power Loss/		Other
	Inspection		Tube	-	Drill Holes	\vdash	Offset	u	L] r Ower 2033/	Juige L	Totaler
	Ripples in Torque V		Evtrucion	, ⊢	Drawing	\vdash	4	Calibration				
	Turning 5			' <u> </u>	Finish	<u> </u>	4	Sequence				
	Wave/Tv	•		-	Folio		1	e Dimensions		····		
	vvave/iv	TIJE III I U	-	1	1.0.00		1 3 4 5 5 7 4 6					

February-07-13 8:24:24 AM

96833

Page 2

Item ID: D3935-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Pylon Protector **Start Date:** 2/07/13 Start Qty: 2.00 **Cust Item ID:** Required Date: 3/22/13 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: ____ Date: ____ Approvals: Tooling: Date: ____ Date:____ SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Code Qty **Qty** Number Stamp 120 QC8- Inspect parts - second check *120* Memo Quality Control 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* 0.00 Memo Quality Control

\$130222

NCR: Yes / No WORK

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

Date:

Well.					·					QA Closed:	Date	:
Work Orde	ŕ•	•			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap] [Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
raitiv	·				Use-as-is	1 1		oforming	Finishing	4	e/Packaging	Other
NCR N	0				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling		ļ										
Operator						:				1		•
Material]			*	_					
Setup												
Other						1						
Process												
Supplier						ł						
Training						ļ						
Unapproved		<u> </u>				<u> </u>						
					F.	AULT	CATE	GORY				
Landin	ng Gear				General				_	7	-	 1
	Bending			<u></u>	Bend	\vdash	Grain		<u></u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	\mathbf{H}	Hardwa		<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on incomplete		Part Incorred	 	Weld
	Crushed/	Crimped			Burrs	Ш	nstruct	ioris Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	L	Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V		- 7
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset					<u></u>
	Torque V	Vaves in I	Extrusio	n [Drawing		Out of (Calibration				
	Turning S	Sequence	!		Finish		Out of S	Sequence				
	Wave/Tv	vist in Tu	be		Folio		Outside	Dimensions				

Picklist Print

February-07-13 8:24:27 AM

Work Order ID: 96833

D3935-2

Parent Item Name: Pylon Protector

96833

D3935-2

Start Date: 2/07/13

Required Date: 3/22/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

Parent Item:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MLEXS.125-F60029-04	_	Purchased	No			100	sf	11.6273	8.69	19 204 77	 •			
*MI FXS 1	25-F60	029 <u>-</u> 04	*				-		**	74/4 /27 4/4			·	

GE PLASTICS LEXAN SHEET

Location Loc Qty Loc Code MAT019 11.6273 11.6273

124654

124654

Page 1

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Skid-tube Water Jeti Crosstube Rework Quality Small Fab Prod. Eng. Coor. Machining Part No. Scrap Rec/Store/Packaging Other Thermoforming Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Action Description of work order update Sign & Initial Root Verification QC Inspector Chief Eng Description Date or Non-conformance Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Grain Bend Bending BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

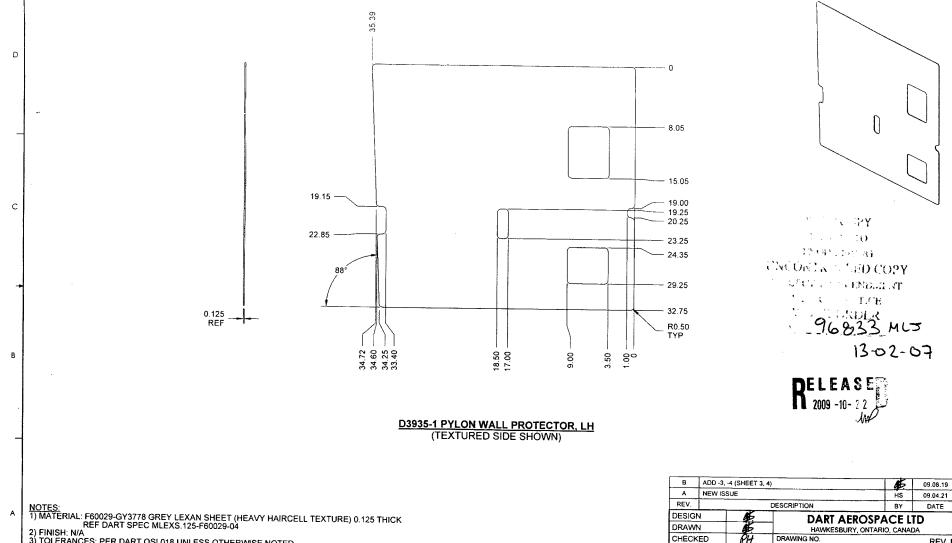
DART AEROSPACE LTD	Work Order:	96833
Description: Pylon Wall Protector, RH	Part Number:	D3935-2
Inspection Dwg: D3935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50"	-		1/	JAMOI
9.00	+/-0.030	9,000	_		V	Productor
14.70	+/-0.030	14.20°			7	Denos
16.20	+/-0.030	1620	_		T	
33.40	+/-0.030	33.40°	_	```	T	
34.25	+/-0.030	34.25	_		1	·
34.60	+/-0.030	34.60"	~		T	
34.72	+/-0.030	34.72"	-		· T	
22.85	+/-0.030	77.85"	_		7	
19.15	+/-0.030	19.15"	_		T	
35.39	+/-0.030	35.39"	_		丁	
8.05	+/-0.030	8.05"	,-		v	
15.05	+/-0.030	15.05	-		т	
19.00	+/-0.030	19.00-	_		<u> </u>	
19.25	+/-0.030	19.25	-			THE STREET
20.25	+/-0.030	2025"	-		T	and the second s
23.25	+/-0.030	23.25	-		Τ	
24.35	+/-0.030	24.35	_		+	4*
29.25	+/-0.030	29.75"			T	
32.75	+/-0.030	32.75"	_		T	
0125	+/-0.010	0.196,,	_		V	**************************************
			- 17			

Measured by: Jm	Audited by:	* 6	Preliminary Approval:	N/A
Date: 3-2-21	Date:	13221	Date:	N/A

Rev	Date	Change	Revised by		Approved
Α	09.06.22	New Issue	KJ	Λ	11
В	10.08.18	Dwg Rev updated	KJ Ž	对一	
				7-	



DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3935 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE **PYLON PROTECTOR** DE APPR. COPYRIGHT © 2009 BY DART ACROSPACE LTD

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NOT TO BE USED FOR MAY PURPOSE OF COURD OF COMMANCATE TO ANY OTHER PERSON WITHOUT

WRITTEN RESULSSION FROM DART ACROSPACE LTD DATE 09.08.19

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER

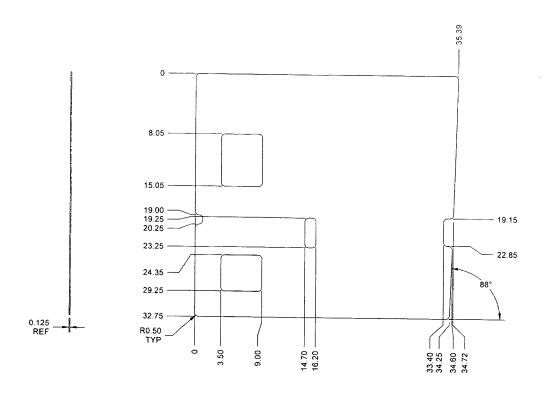
7) WEIGHT: 5.79 lbs

8) CHECK PER TEMPLATE DT8922

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D3935-2 PYLON WALL PROTECTOR, RH (TEXTURED SIDE SHOWN)

5

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04

С

REF DART SPEC MLEXS.125-F60029-04

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-2" AND B/N USING FINE POINT PERMANENT INK MARKER

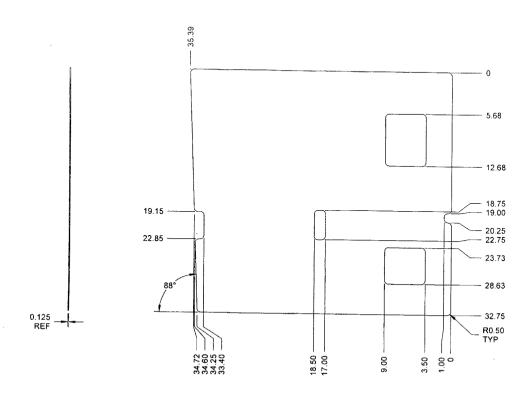
7) WEIGHT: 5.79 lbs

8) CHECK PER TEMPLATE DT8923

DESIGN	1	DART AEROSPACE	LTD			
DRAWN	3 5	HAWKESBURY, ONTARIO, CANADA				
CHECKED	PH	DRAWING NO.	REV. B			
MFG. APPR.	77	D3935	SHEET 2 OF 4			
APPROVED	14	TITLE	SCALE			
DE APPR.	#	PYLON PROTECTOR	NTS			
DATE 09.0	08.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS UPPLIED ON THE COPPRESS CONCEIND THAT IT IS NOT TO SELECTED FOR ANY PROPOSE OR COMPANIENTED TO ANY OTHER RESIDENTIALITY.				

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B D3935-3 PYLON WALL PROTECTOR, LH (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-3" AND B/N USING FINE POINT PERMANENT INK MARKER

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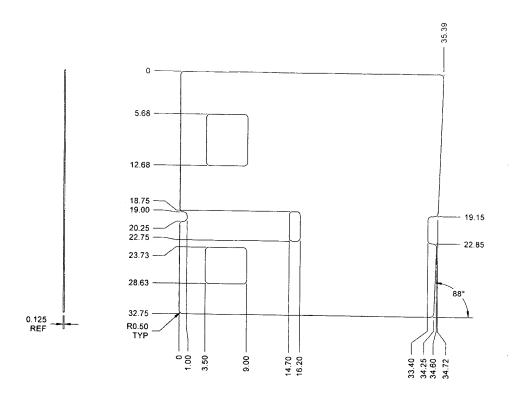
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7) WEIGHT: 5.79 lbs 8) CHECK PER TEMPLATE DT9527

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3935 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE DE APPR **PYLON PROTECTOR** NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD

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D3935-4 PYLON WALL PROTECTOR, RH (TEXTURED SIDE SHOWN)

NOTES: 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04 REF DART SPEC MLEXS.125-F60029-04
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-4" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 lbs
8) CHECK PER TEMPLATE DT9528

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3935 MFG. APPR SHEET 4 OF 4 APPROVED TITLE SCALE **PYLON PROTECTOR** DE APPR. DATE 09.08.19

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